

S157836



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6201
Job Sheet 191209



Part No: D6201

Job Qty: 20 ft

Part Name: T Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 3/6/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	DAS 20 ft		3/6/19	0.00	0.00	Purchasing - 1		
	FEB 25 2019	13					Purchasing - 2		
		9-89					Purchasing - 3		
110	Packaging	20 pcs		3/6/19	0.00	0.00	Packaging2		
120	QC	20 pcs		3/6/19	0.00	0.00	QC6		
130	Packaging	20 pcs		3/6/19	0.00	0.00	Packaging3-2		
140	QC 21 - SA FT	20 ft		3/6/19	0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op 100 - Issue P/O: _____ a) Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile
Descriptions: Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)
110 - Ensure material certification is attached
120 - Ensure Material certification comply to Dwg D6201
130 - LOCATION: MAT028

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201P	T Extrusion 4X4X3/8	20 ft (1 ea)	100-Purchasing - Ft	S157830

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6201P	20	0	0

Part Specifications

Specifications could not be found.

Plex 2/25/19 8:06 AM dart.lavoie.chantal



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042696



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

PO No: PO042696

PO Date: 2/25/19

Due Date: 3/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
FEB 25 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1 <i>AT</i>	191209	D6201P		T Extrusion 4X4X3/8 AS PER DWG D6201 REV. A	Firmed	-	3/6/19	20 ft <i>✓ 20 ft</i>	0 ft	20 ft <i>AT 191209</i>	\$23.00/ft	\$460.00
Grand Total:												\$460.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/25/19 8:27 AM dart.lavoie.chantal

6434

TBAL-4438

53483

23951N

C129820



SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

05/31/2015		5357009		118419		1	
PO37565		020743		852198 <i>Paulie</i>		05/31/15	
42081 A S A ALLOYS INC. 81 STEINWAY BOULEVARD ETOBICOKE, ON M9W 6H6 CANADA				42081 A S A ALLOYS INC. 81 STEINWAY BOULEVARD ETOBICOKE, ON M9W 6H6 CANADA			
002	C-031522-10	240" MILL 6061 T6511			3/8X4X4" TEE ALUMINUM		
774 LBS							
752 LBS		11 PCS		1 PKGS			
ASTM B221-08							

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
334.5 / 48.5	304.2 / 44.1	15.4	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.24	0.19	0.06	0.87	0.06	0.06	0.02	0.01	0.00

Heat: 852198

This Material is Made in Canada

This Material is RoHS Compliant

magne
Bravo
4" X 4" X 3/8
8/6 X 1/4 X 1/2

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

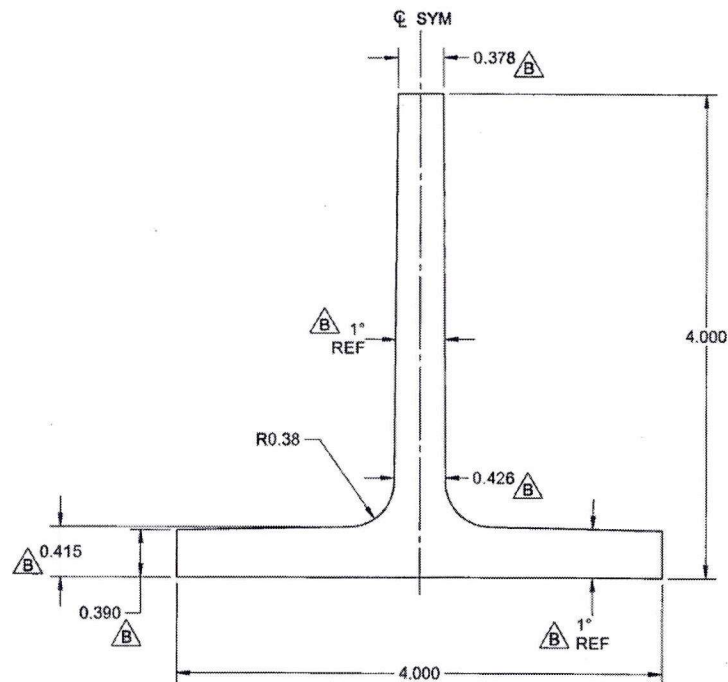
ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com



4447 3/8
June 2015
TL

SPECIFICATION CONTROL DRAWING



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES
EG. 27 INCHES LONG EXTRUSION: D6201-027

NOTES:

- 1) MATERIAL: ALUMINUM T-EXTRUSION, ROUND FILLET
6061-T6 (T651) PER AMS-QQ-A-200/8 OR QQ-A-200/8 OR ASTM B221
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.67 lb/ft

RELEASED
2017-07-27
EON 17-660

B	REFORMAT TO CURRENT STANDARDS: 1° TAPERS DEFINED BY 0.378 & 0.426 AND 0.390 & 0.415 WERE NON-TAPERS (0.375). REASON: CAR17-184. UPDATE MATERIAL CALLOUT.	ML	17.06.05
A	NEW ISSUE	CP	01.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	LL	D6201	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	T-BEAM EXTRUSION	NTS
DATE	17.06.05	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6201

PO / BATCH NO.: P0042696/S157836

DATE: 19/02/28

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 4.000"

QUANTITY RECEIVED: 2054

THICKNESS RECEIVED: 4.000"

QUANTITY INSPECTED: 2054

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	☒	☐	<u>A couple dents</u>
CORRECT FINISH	☒	☐	
CORROSION	☐	☒	
CORRECT GRAIN DIRECTION	☒	☐	<u>ASTM B221</u>
CORRECT MATERIAL PER M-DRAWING	☒	☐	
CORRECT THICKNESS	☒	☐	
PHOTO REQUIRED	☐	☒	<u>HT: 852-198</u>
CORRECT REF # TO LINK CERT	☒	☐	
CORRECT MATERIAL IDENTIFICATION	☒	☐	
CORRECT M# ON THE MATERIAL	☒	☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☐	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	☐	☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 61 9-89</u>	SIGNED OFF BY: _____
DATE: <u>FEB 28 2019</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in